

Date: Thursday, 2/8/2007 12:06:09 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRUT
Job Number : 30690	
Estimate Number : 12704	
P.O. Number : N/A	Part Number : D35501
This Issue : 2/8/2007 S.O. No. : N/A	Drawing Number : D3550 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 30637	Material : N/A
Written By : <u>JA</u>	Due Date : 2/15/2007
Checked & Approved By : <u>JA 07.02.02</u>	Qty: 50 Um: Each
Comment : Est. A 07.02.05 New issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304TR0500W049	304 RD Tube .500 x .049W
-----	----------------	--------------------------



Comment: Qty.: 1.7850 f(s)/Unit Total : 89.2500 f(s).
 304 RD Tube .500 x .049W
 304/316 Seamless tubing, 1/2" OD x .049 Wall

M103629 19

Batch M102742 28 83 07/03/07

40

49.98

2.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE
 1-Form per Dwg D3550

FF 07-03-01 47

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

FF 07-03-05 47

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

07/03/05 45

5.0	POWDER COATING	POWDER COATING
-----	----------------	----------------

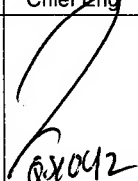
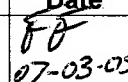

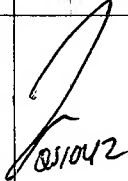



Comment: POWDER COATING
 Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M103141 07-03-06 45

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/03/05	3.0	Wedge Flat end 1.8" was to short .200" off	 08/04/2	-destroy two	 07-03-05	 07/03/05	 08/04/2	 07/03/05

NOTE: Date & initial all entries

Date: Thursday, 2/8/2007 12:06:10 PM
User: Kiri Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 30690

Part Number: D35501

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U OK-03-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

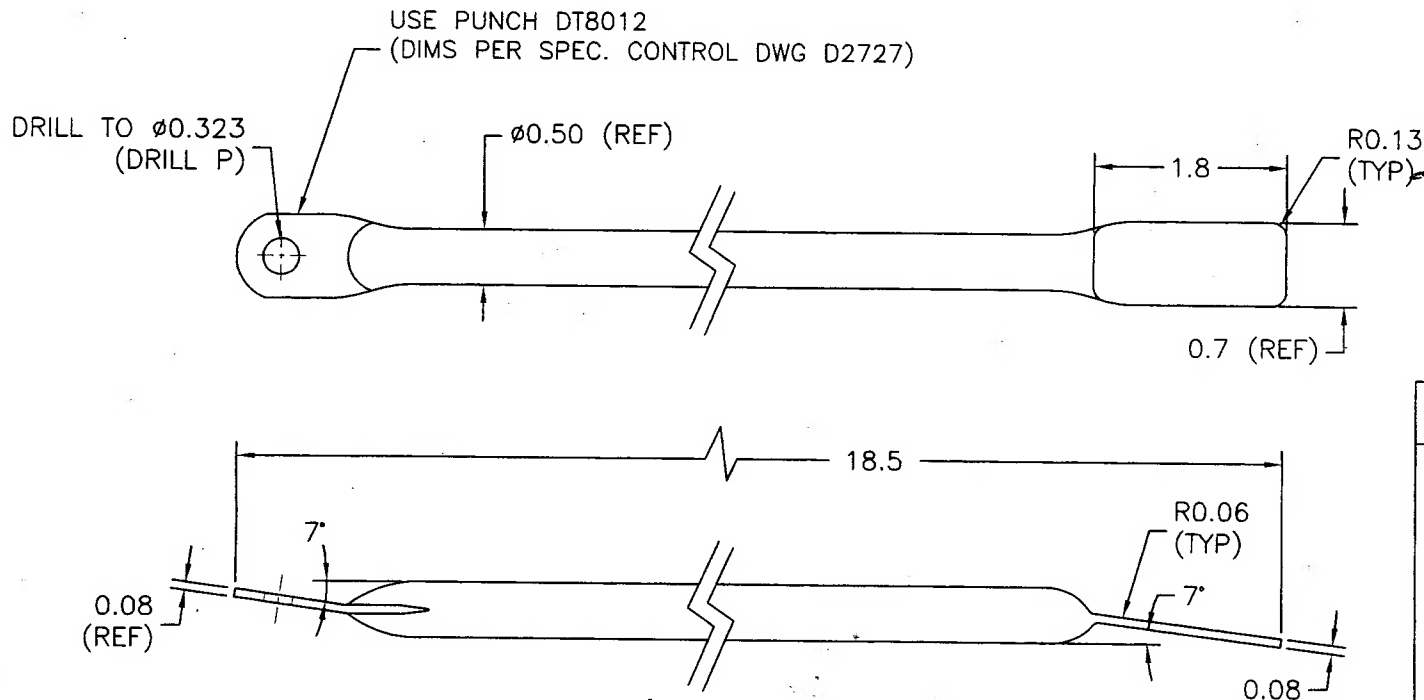
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

UNDER REVIEW

07.02.22 LE

DESIGN	DRAWN BY	DART AEROSPACE LTD
CE	CE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
PH		D3550
DATE	TITLE	REV. B
07.02.13	STRUT	1 OF 1
		SCALE
		NTS
A	06.10.24	NEW ISSUE
B	07.02.13	18.5 WAS 20.13; 1.8 WAS 1.5



D3550-1 STRUT

NOTES:

- 1) MATERIAL: 304/316 SS SEAMLESS ROUND TUBE 0.500 OD X 0.049 WALL (REF DART SPEC M304TR0.500W.049)
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3550-1 USING FINE POINT PERMANENT INK MARKER

Copyright © 2006 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.